

Work Order ID 57117

March 23, 2010 8:20:58 AM



Page 1

Item ID: D3908-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Plate, Aft Crosstube

Start Date: 23/03/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 25/03/2010 Req'd Qty: 16.00

Customer:

Reference:

Ind 10-03-23

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3908

A

100

0.00



Waterjet

FLOW CNC Waterjet

304 .125

Memo

0.00

Cut as per dwg D3908

Prog Rev: *A*

Dwg Rev: *A*

Deburr as required

FB 10-3-23



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

FB 10-3-23

Pho 7

Dart Aerospace Ltd

W/O: 57117 .

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/3/23	#120	Took Qty +1 For QC inspection template	J	10/3/23	#1		J 10/03/23

Part No: D3908-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 25/03/2010 Req'd Qty: 16.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

Memo

5 10/6/23

(4/6)

150



Packaging

Packaging

Identify as per dwg & Stock Location: 095

0.00

0.00

Memo

P 14/3/24 (16)

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10 603/24
MF
10-3-24

Picklist Print

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Page 1

Work Order ID: 57117

Parent Item: D3908-1

Parent Item Name: Lug Plate, Aft Crosstube



Comments: IPP RevA: new issue DD 09.11.17 verified by:EC

Start Date: 23/03/2010

Required Date: 25/03/2010

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	55.5036	0.8977			
304/316 0.125 Sheet 												

B10-3-23

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	55.5036	
112663	55.5036	112663

15

DART AEROSPACE LTD		Work Order: 57117
Description: LUG PLATE AFT CROSS TUBE		Part Number: D3908-1
Inspection Dwg: D3908-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

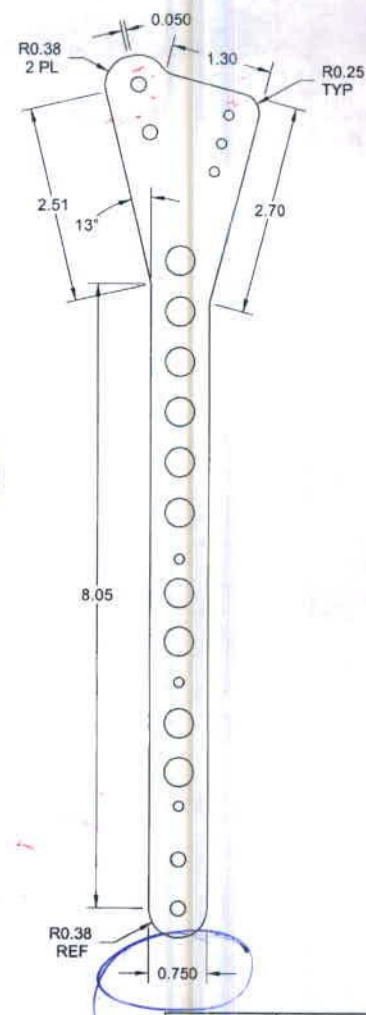
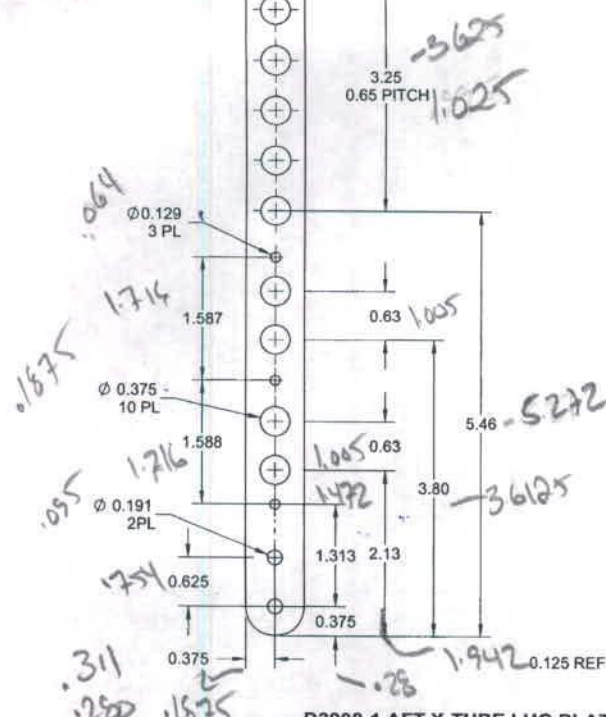
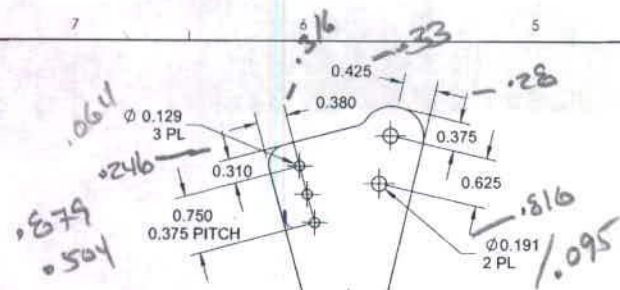
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.131	X			
Ø .375	+ .006 - .001	.376	X			
Ø .191	+ .005 - .001	.193	X			
Ø .310	± .010	.311	X			
.750	± .010	.750	X			
.375	± .010	.375	X			
.380	± .010	.381	X			
.425	± .010	.426	X			
.625	± .010	.624	X			
3.25	± .030	3.253	X			
.65	± .030	.654	X			
.63	± .030	.628	X			
1.587	± .010	1.580	X			
5.46	± .030	5.463	X			
3.80	± .030	3.800	X			
.63	± .030	.629	X			
2.13	± .030	2.120	X			
1.313	± .010	1.315	X			
.375	± .010	.375	X			
.625	± .010	.625	X			
1.588	± .010	1.588	X			
.125	± .010	.120	X			
11.34	± .030	11.332	X			
.750	± .010	.759	X			

Measured by: HB
Date: 10-3-23

Audited by: S
Date: 10/05/23

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



w/o 57117

RELEASED
2010-03-12
MP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.32 lbs

D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D3908	SHEET 3 OF 4
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	X-TUBE LUG ASSY (AFT)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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